



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043
Job Sheet 195764



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	8.24	Skidtubes - 1		TF 100
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/5/19		1.00	22.77	HAAS - 1 - B4B		M.M. 2019/06/23
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs	7/5/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S187883



Part: D5425-043

Job No: 195764

Serial No/Batch: S187883

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/05/19

Plex 5/30/19 10:47 AM Dart.Guerin.Kimberley

					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	1	7/5/19	0.00 0.00	QC 8 - 12	
		pcs			QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
150	Handfinish - 1-1 Chemical-B4B	1	7/5/19	0.00 0.24	Handfinish - 1 - 1 - B4B	
		pcs			Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 -	

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M.M. 20/1/04/23

Pmk 19/06/24

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				B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MGC
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
170 Skidtubes - Bend - 2 - B4B	1 pcs	7/5/19	0.50 2.63	Skidtubes - Bend - B4B	MGC
180 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BB
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	

				QC 5 - 30	
				QC 5 - 40	
190 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
210 Handfinish - 6-1- Touch Up- B4B	1 pcs	7/5/19	0.00 0.24	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	BB Jy
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	

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220 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/5/19	0.00 0.00	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	

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				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
260 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
270 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00 0.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 19-7-11
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
280 QC 14	1 pcs	7/5/19	0.00 0.00	QC 14 - 15	ul 19-7-15

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					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
282	Outsource - 11 - Paint	N/R 1 pcs	7/5/19		ATE003-VC	2
284	Packaging 2-1 - Receive - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
286	QC 6	NR 1 pcs	7/5/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
290	Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 0.24	Handfinish - 4 - 1 - B4B	ul 14-7-17
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 -	

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				B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
300	QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
310	Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B

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					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	DAS
					Packaging 3 - 35 - B4B	21
					Packaging 3 - 36 - B4B	9-89
320 QC 21 - SA	1 pcs	7/5/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Debur ends as per Dwg.

Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: _____ FOLIO REV: _____ 2-Debur as per Dwg.

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - 1-Scrub inside of tube with medium scotchbright.

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Bend Aft end of tube as per Dwg. and Folio _____. Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 4.375 2-Bend Forward end of tube as per Dwg. and Folio _____. Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 7.4 3-Record dimensions on work order.

180 - (QC5- Inspect part completeness to step on W/O)

190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.

200 - (QC5- Inspect part completeness to step on W/O)

220 - (QC7-Inspect Chemical Conversion Coat)

230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B _____ Start Time: _____ Finish Time: _____ ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1

240 - (QC5- Inspect part completeness to step on W/O)

250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***

260 - (QC7-Inspect Chemical Conversion Coat)

270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5189559 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5188693

280 - (QC14- Inspect Spray Paint)

282 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

284 - C OF C IS REQUIRED

290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B _____ Exp: _____ Start time: _____ Finish time: _____ 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B 5132690

300 - (QC5- Inspect part completeness to step on W/O)

310 - (Identify as per dwg & Stock Location: _____)

320 - (QC21- Final Inspection - Work Order Release)

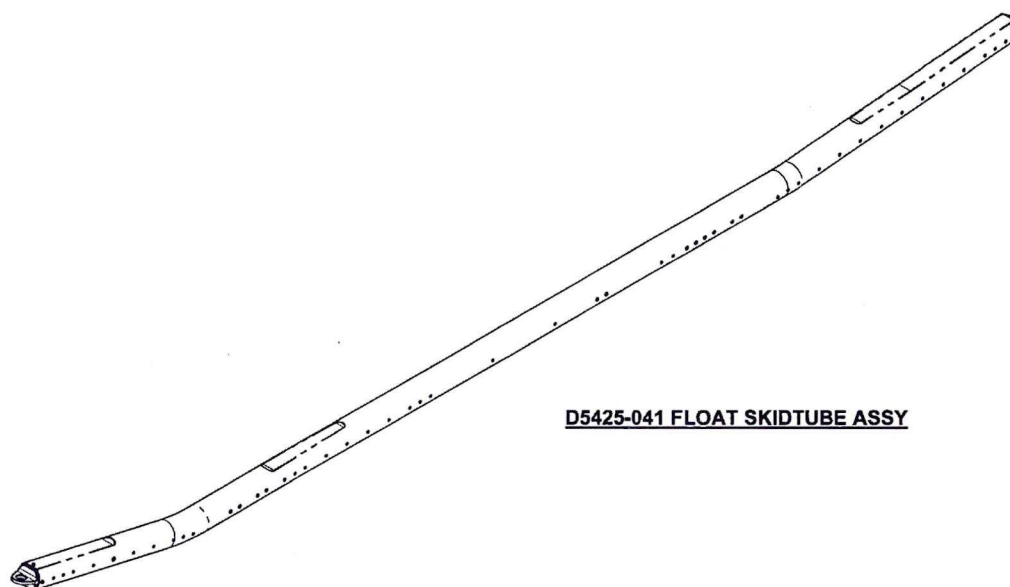
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	010887
D5518-1	Crossbolt Spacer	20 48 pcs (18 ea)	230-Skidtubes - 3 - B4B	5183903 SK 7596
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	5187624
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	519214d
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	FLG 4008
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	5150717
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	5151947
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	5150078

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	0	0
230-Skidtubes - 3 - B4B	D5512-1	12	42	0
	D5518-1	18	272	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	1,224	0
	D3672-1	6	1,727	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	3,344	0
Part Specifications				
Specifications could not be found.				

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QTY -041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



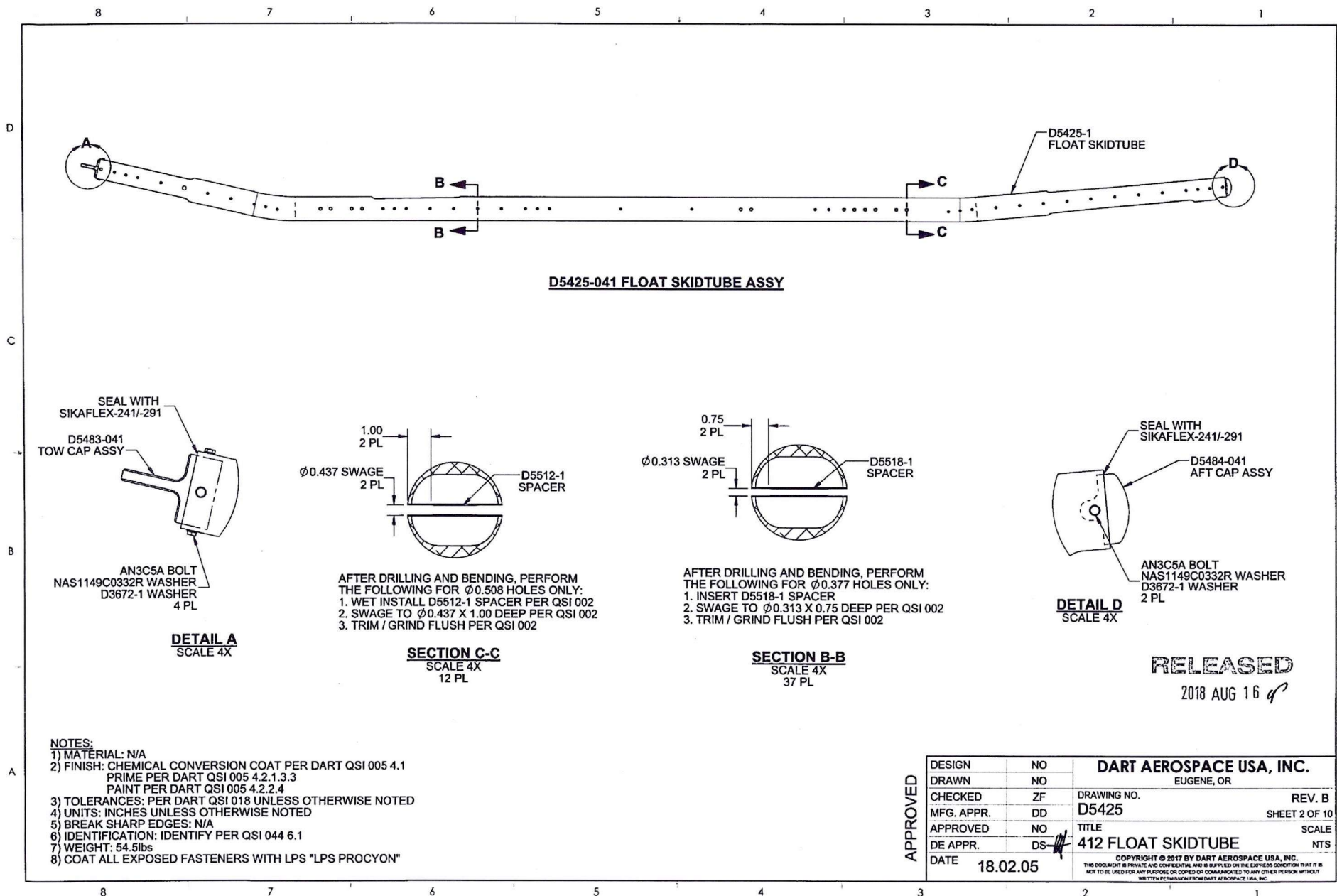
D5425-041 FLOAT SKIDTUBE ASSY

RELEASED

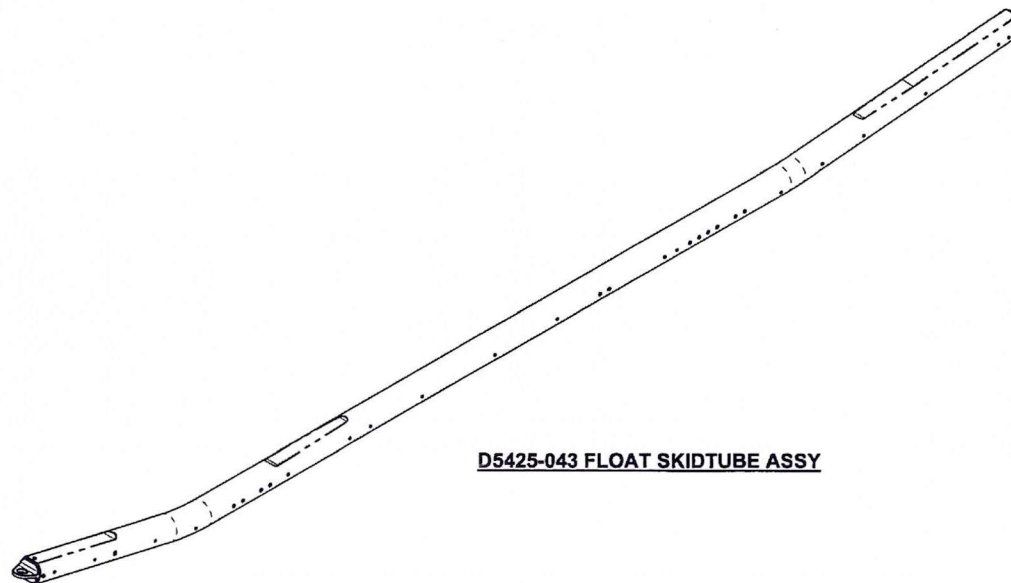
2018 AUG 16
ECN 18-736

B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEETS 5 AND 6 (NCR18-6741). PICTORIAL UPDATE DUE TO CHANGES IN D5483-1.	NO	18.02.05
A	NEW ISSUE	NO	17.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 1 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED



QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



D5425-043 FLOAT SKIDTUBE ASSY

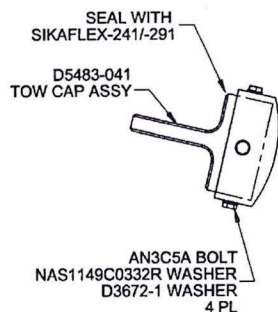
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2018 AUG 16 *JP*

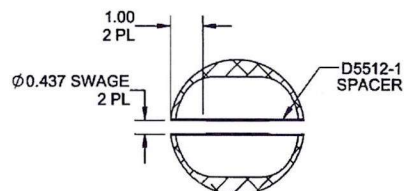
APPROVED

DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	NO		
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 3 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	D5 <i>JP</i>	412 FLOAT SKIDTUBE	NTS
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D5425-043 FLOAT SKIDTUBE ASSY

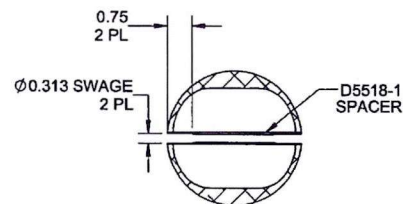


DETAIL E
SCALE 4X



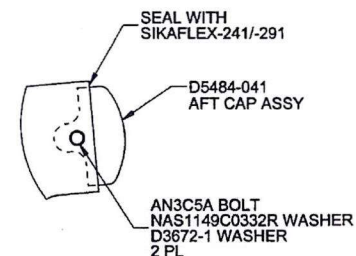
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR $\phi 0.508$ HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO $\phi 0.437 \times 1.00$ DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION G-G
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR $\phi 0.377$ HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO $\phi 0.313 \times 0.75$ DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION F-F
SCALE 4X
18 PL



DETAIL H
SCALE 4X

RELEASED

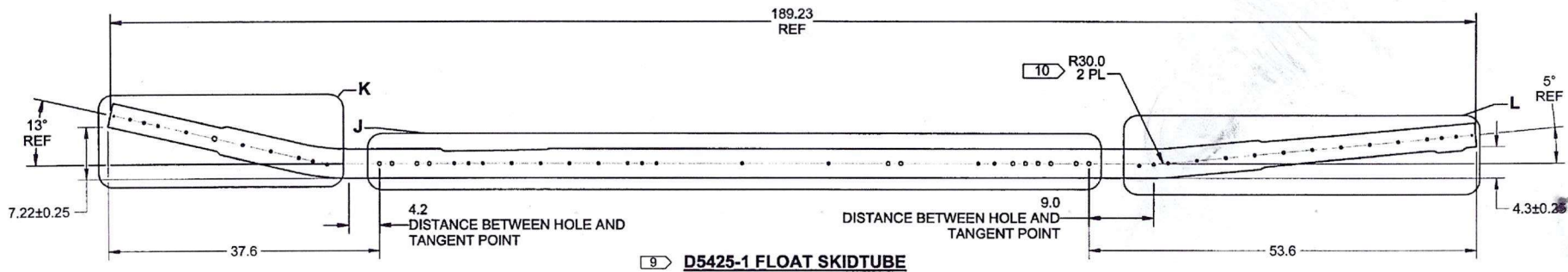
2018 AUG 16

NOTES:

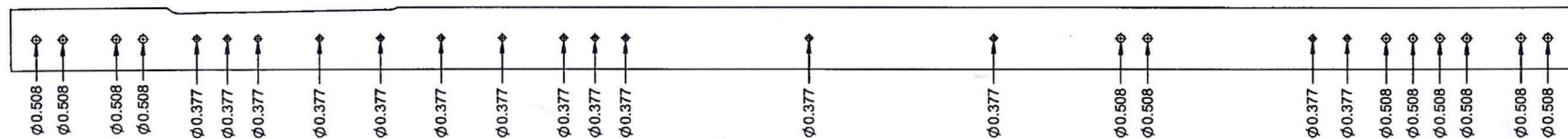
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 54.3lbs
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

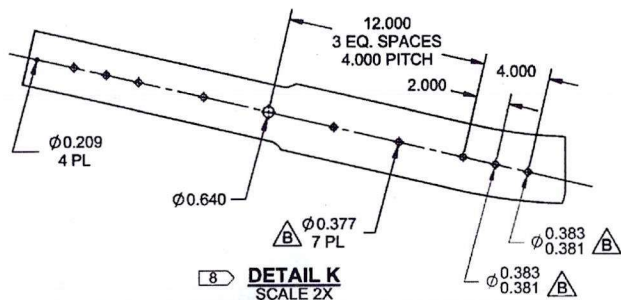
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 4 OF 10
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DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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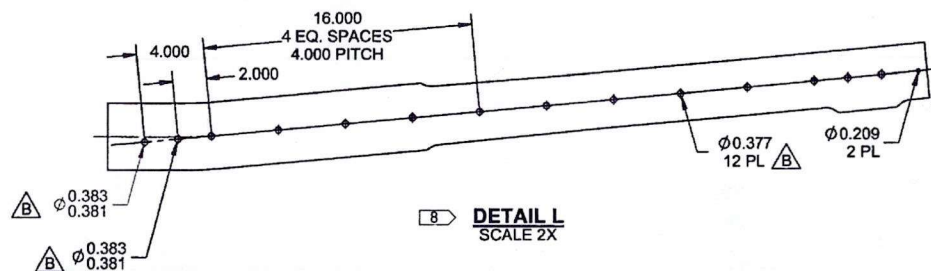
9 D5425-1 FLOAT SKIDTUBE



8 DETAIL J
SCALE 2X



8 DETAIL K
SCALE 2X



8 DETAIL L
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D5425-1DRILL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
- 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
- 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

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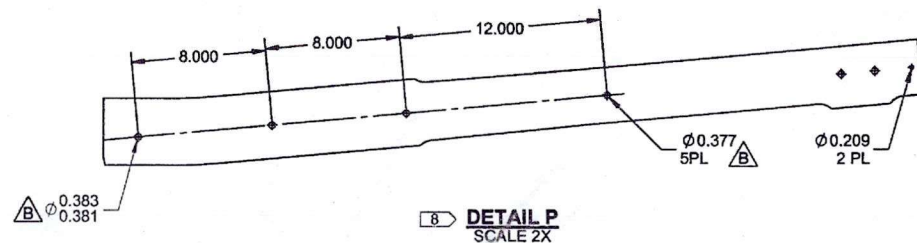
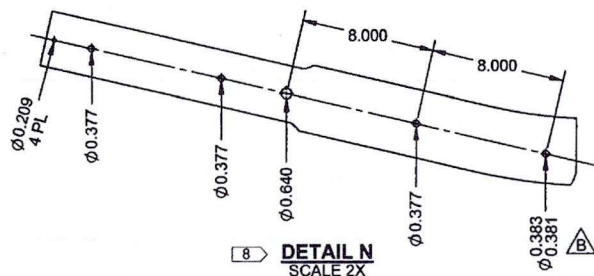
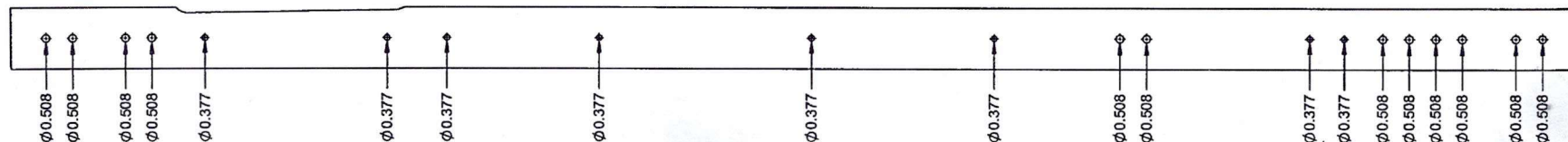
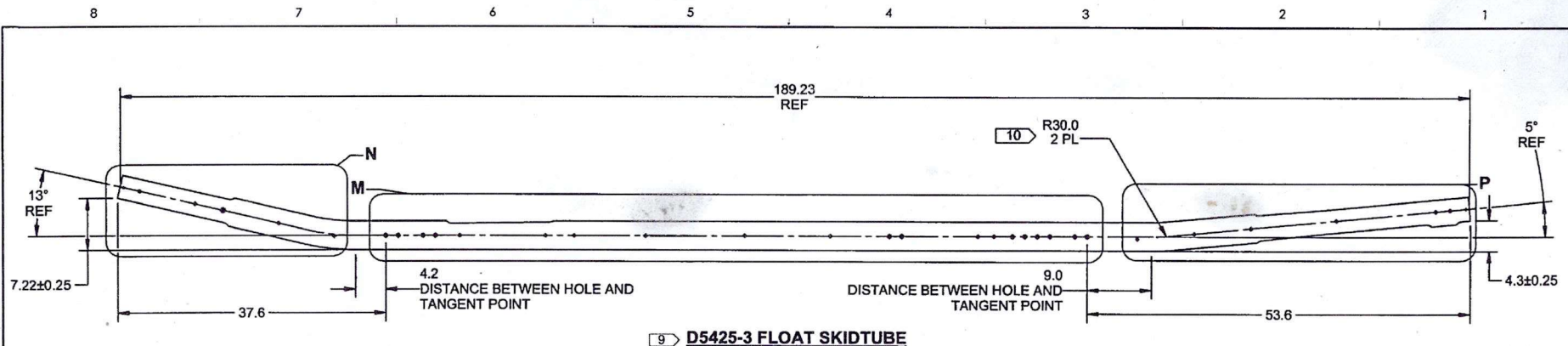
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DESIGN	NO
DRAWN	NO
CHECKED	ZF
MFG. APPR.	DD
APPROVED	NO
DE APPR.	DS
DATE	18.02.05

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. D5425
TITLE 412 FLOAT SKIDTUBE
REV. B
SHEET 5 OF 10
SCALE NTS

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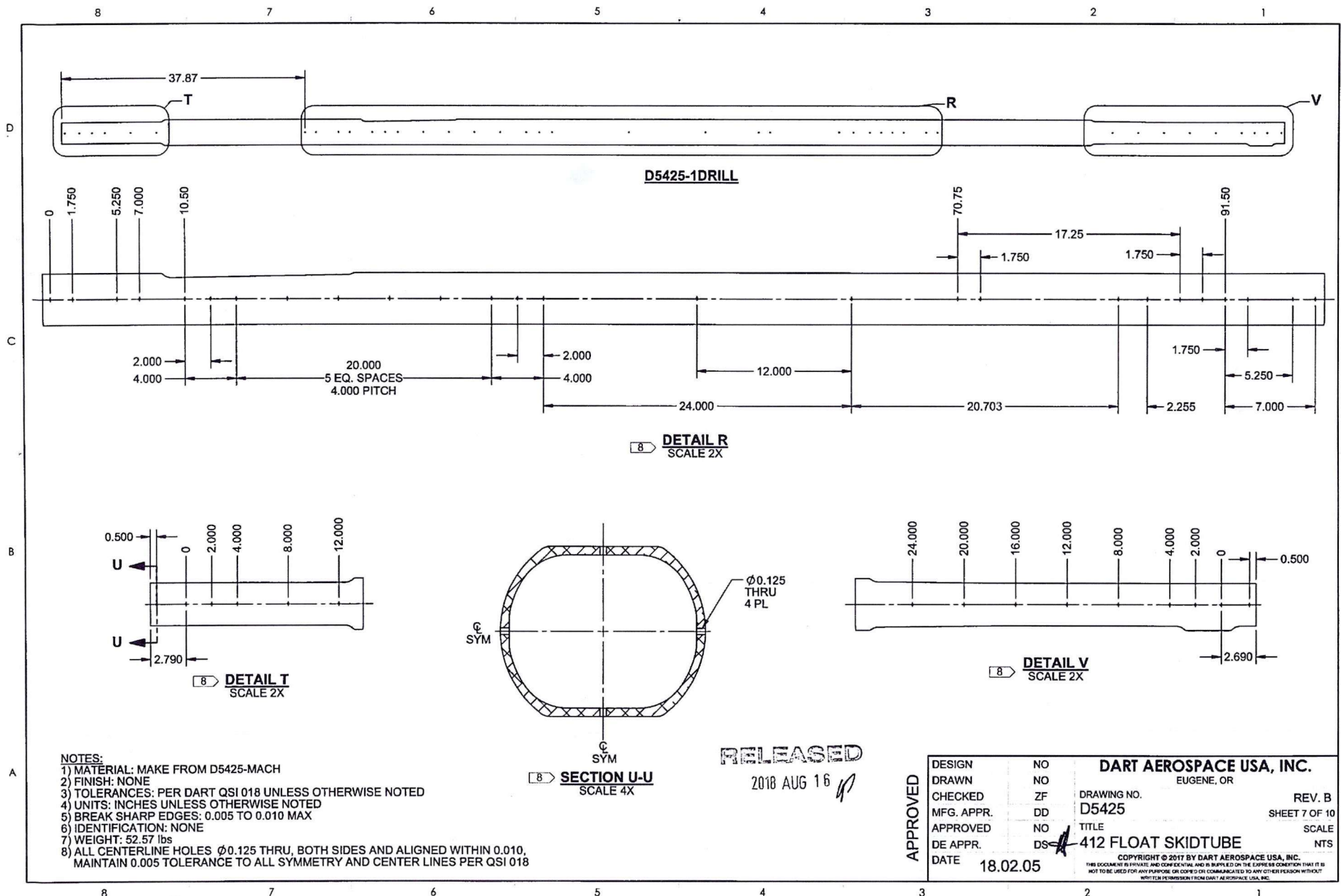
- 1) MATERIAL: MAKE FROM D5425-3DRILL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 52.57 lbs
- 8) ALL HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
- 9) MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM EXTRUSION CENTERLINE AT ANY POINT
- 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

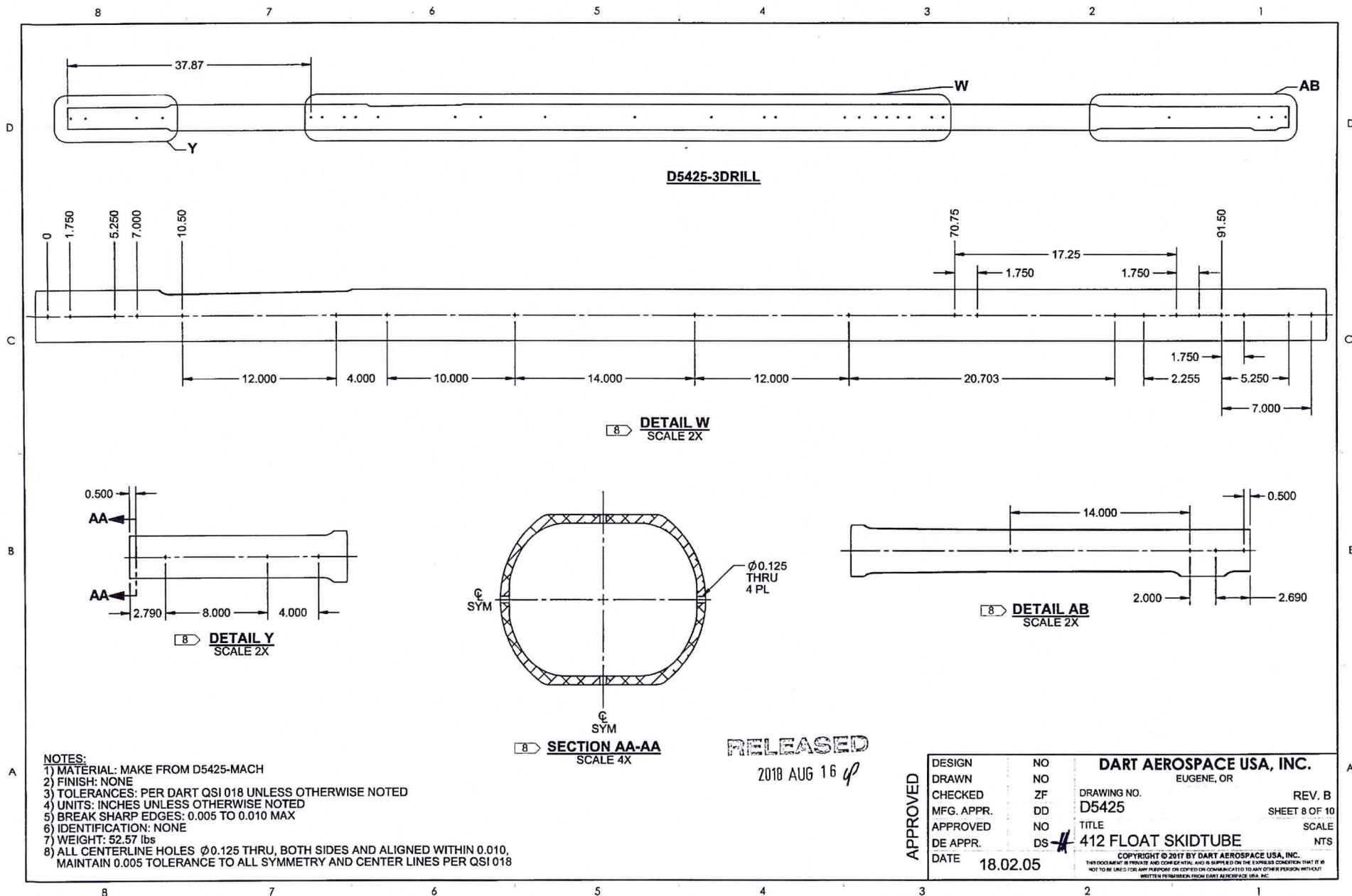
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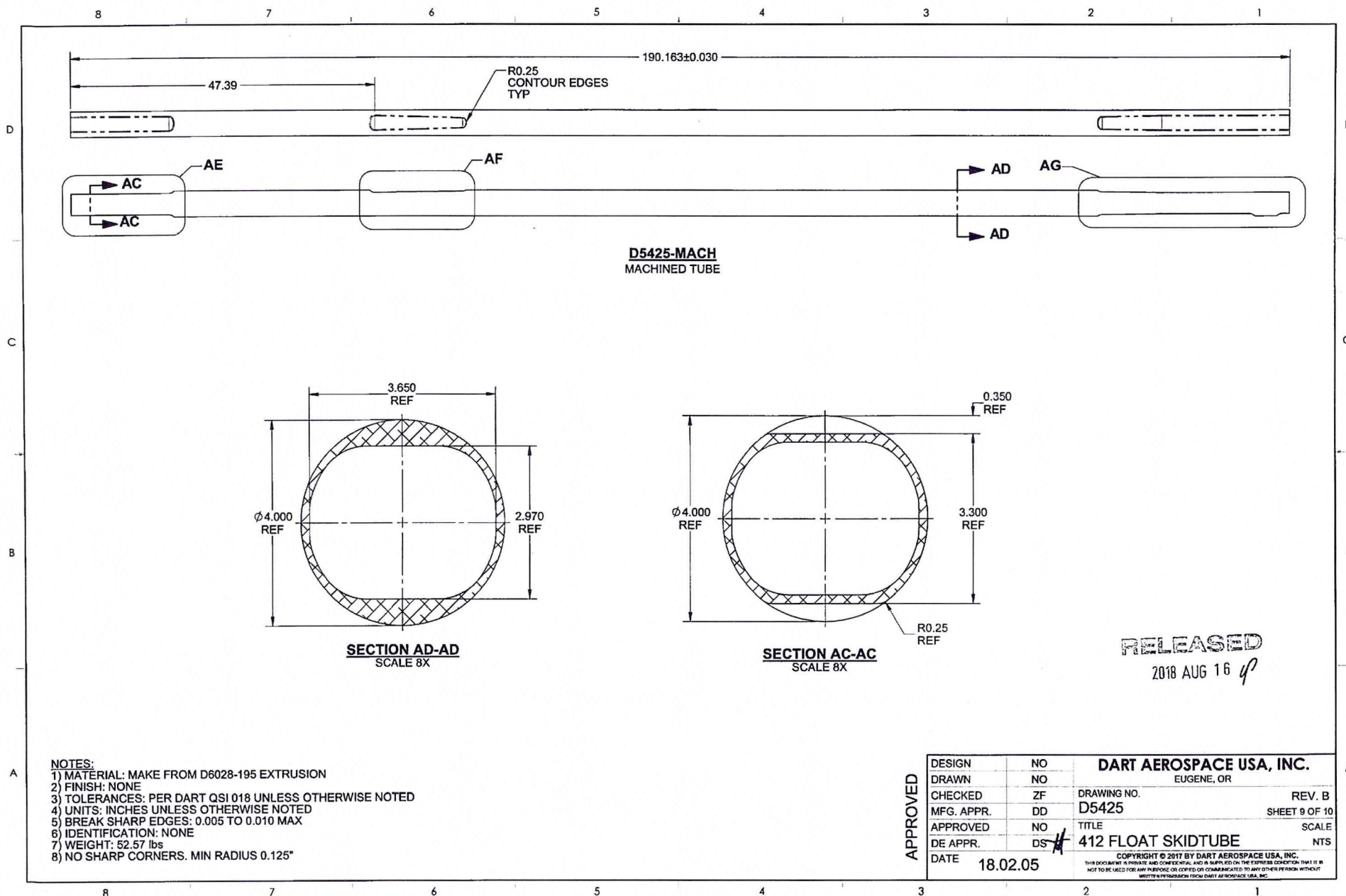
2018 AUG 16

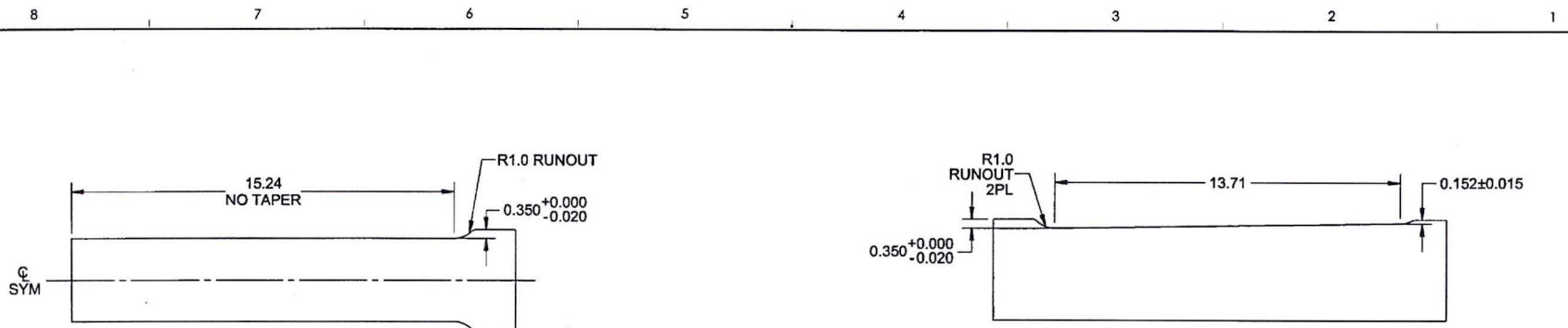
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DESIGN	NO	DART AEROSPACE USA, INC.	
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CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 6 OF 10
APPROVED	NO	TITLE	SCALE
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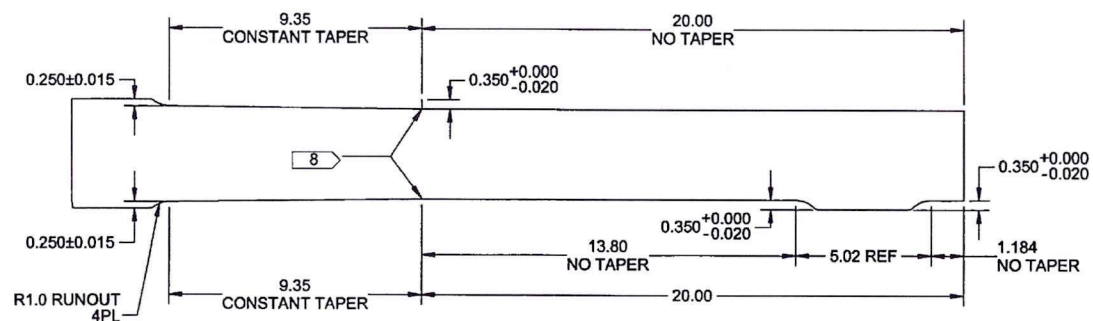






DETAIL AE
SCALE 3X

DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

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2018 AUG 16 *q*

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	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 10 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DSS	412 FLOAT SKIDTUBE	NTS
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DART AEROSPACE LTD		Work Order: 195769
Description: 412 FLOAT SKIDTUBE		Part Number: D5425-3
Inspection Dwg: D5425 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	.5005	✓		vernier	
2.790	+/- .010	2.791	✓		vernier	
10.790	+/- .010	10.790	✓		Tape	
14.790	+/- .010	14.790	✓			
43.120	+/- .010	43.125	✓			
44.870	+/- .010	44.875	✓			
48.37	+/- .010	48.375	✓			
60.37	+/- .010	60.375	✓			
64.37	+/- .010	64.375	✓			
74.37	+/- .010	74.375	✓			
123.328	+/- .010	123.325	✓			
125.87	+/- .010	125.875	✓			
129.37	+/- .010	129.375	✓			
131.12	+/- .010	131.125	✓			
134.62	+/- .010	134.625	✓			
136.37	+/- .010	136.375	✓		Tape	
0.500	+/- .010	.501	✓		vernier	
2.690	+/- .010	2.692	✓		vernier	
4.69	+/- .010	4.695	✓		vernier	
18.69	+/- .010	18.687	✓		vernier	
15.24	+/- .030	15.24	✓		the Tape	
R1.0	+/- .100	R1.0	✓		Gaborix	
0.350	+ .000/- .020	.348	✓		palpeur	
0.350	+ .000/- .020	.340	✓		palpeur	
R1.0	+/- .100	R1.0	✓		Gaborix	
13.71	+/- .030	13.725	✓		Tape	
0.152	+/- .015	.148	✓		palpeur	
0.250	+/- .015	.238	✓		palpeur	
9.35	+/- .030	9.35	✓		Tape	
0.350	+ .000/- .020	.339	✓		palpeur	
20.00	+/- .030	20.00	✓		Tape	
0.250	+/- .015	.235	✓		palpeur	

Measured by: M.M. 54	Checked by: J.M.	QC Inspector:
Date: 2019/06/23	Date: 19/06/24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

0655

